

Date
UserWednesday, 15/08/2007 4:00:47 PM
Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : RING

Job Number : 33949

Estimate Number : 10795

P.C. Number : N/A

This Issue : 15/08/2007 S.O. No. : N/A

Prsht Rev. : NC

First Issue : N/A Type : SMALL / MED FAB

Previous Run : 33433

Part Number : D34131

Drawing Number : D3413 REV A

Project Number : N/A

Drawing Revision : A

Material : N/A

Due Date : 31/08/2007

Qty: 75 Um: Each

Written By : JLM/07-08-16

Checked & Approved By :

Comment : Est Rev:A 05.09.13 New issue KJ/JLM

Est Rev:B Now on Waterjet 07-05-28 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3413

Dwg Rev: A

Prog Rev: A

M#

IB 07-08-23

(87)

2-Deburr if necessary

2.0

M304B0250X4000

304 BAR .250 x 4.00



Comment: Qty.: 0.2625 f(s)/Unit Total: 10.5000 f(s)

304 BAR .250 x 4.00

Batch: M105 358

IB 07-08-23

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 07-08-23

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

EN 07/08/23

x87

center

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1.

SAD 07/09/16

(87)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/09/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 4:00:47 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 33949

Part Number: D34131

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counters
En 2/09/00 (887)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M105068
m-l 07/04/21 (87X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

HA 07-09-21 (87)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 9475

07/09/27 (87)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



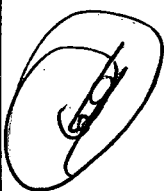
Comment: FINAL INSPECTION/W/O RELEASE

(87)
07/09/24

Job Completion



07-09-24



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

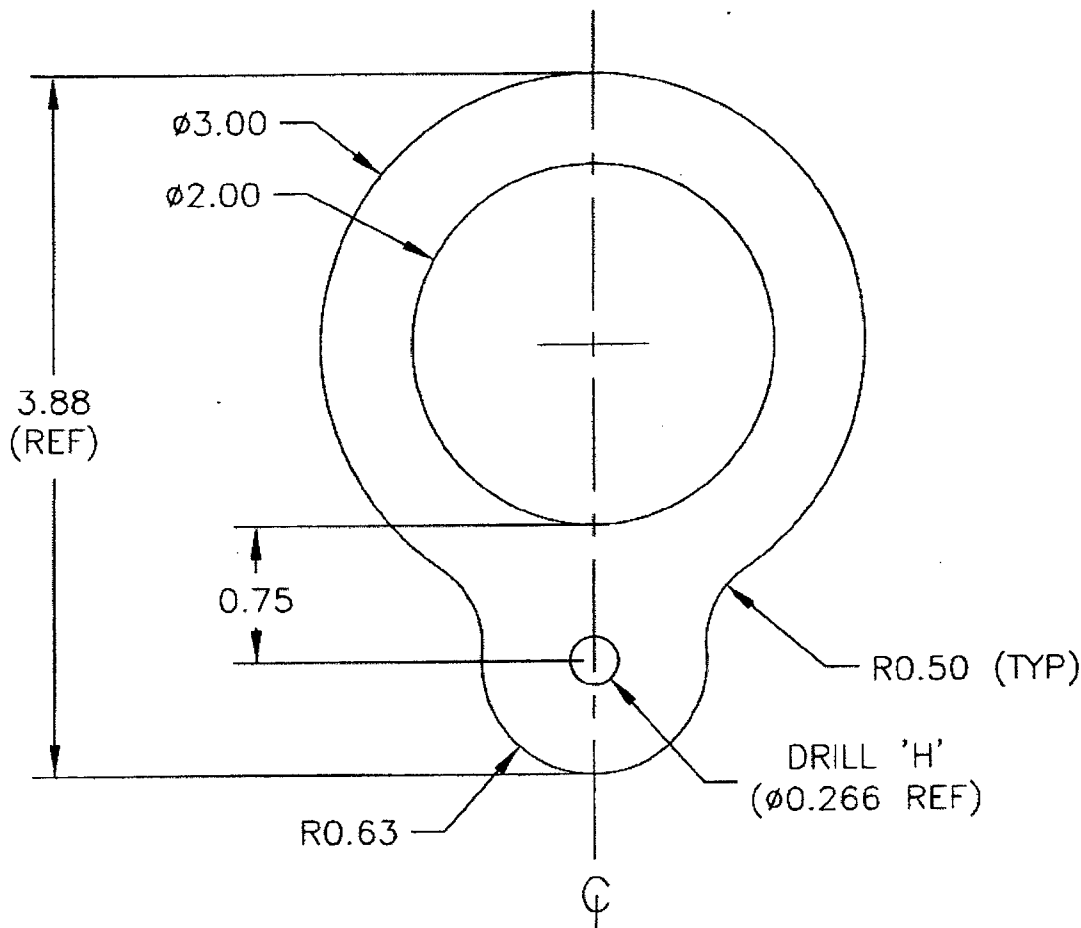
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3413
				REV. A SHEET 1 OF 1
DATE	05.03.16	TITLE	RING	SCALE 1:1
A	05.03.16	NEW ISSUE		

RELEASED
05-09-06 *[Signature]***D3413-1 RING**

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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